

Work Order ID 109747

November-28-13 7:41:06 AM

109747

Page 1

Item ID: D3417-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Washer

Start Date: 11/28/13 Start Qty: 100.00

100

Cust Item ID:

Required Date: 11/29/13 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3417	Rev F

100	Hardinge CNC LATHE SMALL	0.00				120	φ		
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100									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA761 Rev: A & Dwg D3417 Rev: F 2-Deburr		SA	13-11-28					

110	QC2- Inspect parts off machine FAI/FAIB	0.00				120	φ		
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110									
QC	Memo	0.00							
Quality Control			SA	13-11-28					

120	QC8- Inspect parts - second check	0.00				120	φ		
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120									
QC	Memo	0.00							
Quality Control				13/11/29					

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November-28-13 7:41:06 AM

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Page 2

Item ID: D3417-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Washer
Start Date: 11/28/13 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 11/29/13 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>STAR</u>	0.00							
130									
Packaging	Memo	0.00				<u>20x</u>			<u>13-12-2</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				<u>ML5</u>			<u>13-12-02</u>
Quality Control									

DAS
26
9-89

u 13-12-02

Picklist Print

November-28-13 7:41:05 AM

Page 1

Work Order ID: 109747

Parent Item: D3417-5

Parent Item Name: Washer

Start Date: 11/28/13

Required Date: 11/29/13

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev: A New issue 08-07-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500 DELRIN ROUND BAR 1.25"		Purchased	No			110	f	10.3000	0.0296	514		13-11-25	

Location

Loc Qty

Loc Code

MAT018

10.3

m126596

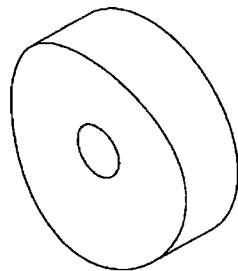
10.3

4.5 27

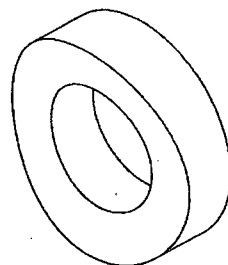
~~27~~
~~15.5~~

MDELNR1.25
M126596

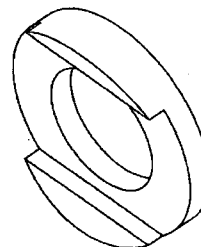
8 7 6 5 4 3 2 1



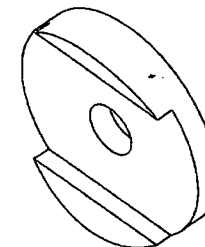
D3417-1 WASHER



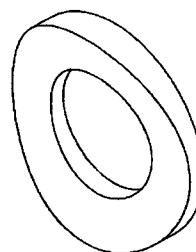
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



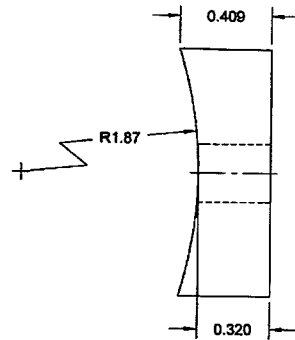
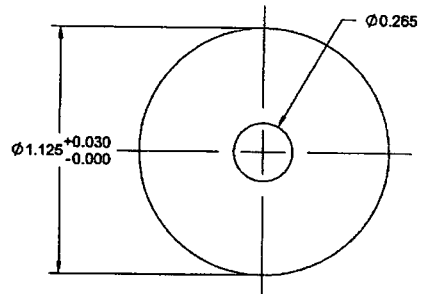
D3417-9 WASHER

RELEASED
2010-09-15

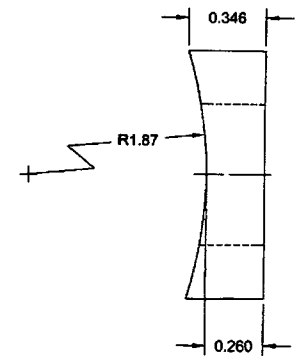
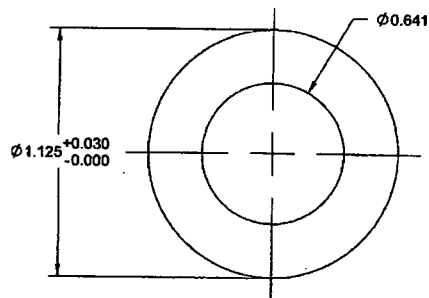
NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

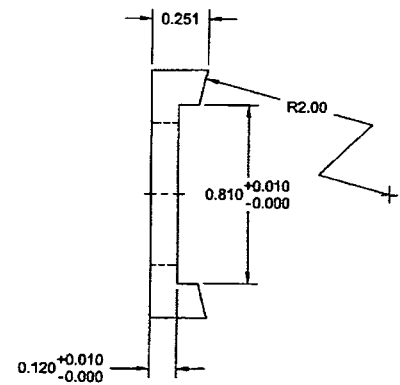
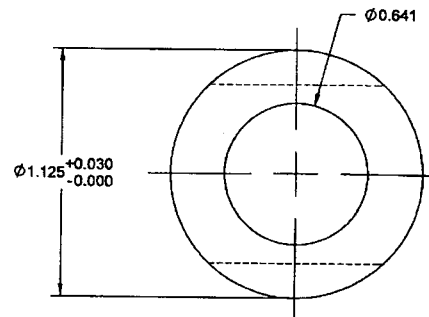
F	ADD D3417-9 (ZN B5-3)	SC	10.07.28
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGINALLY OR OTHERWISE REPRODUCED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



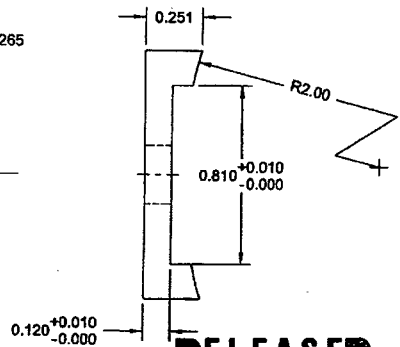
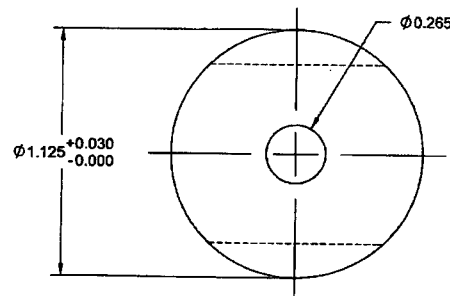
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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